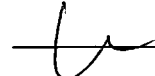



Date: Tuesday, 27/05/2008 12:37:40 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INNER AFT SADDLE	
<b>Job Number</b> :	39510			
<b>Estimate Number</b> :	11082			
<b>P.O. Number</b> :		<b>Part Number</b> :	D5957	
<b>This Issue</b> :	27/05/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D5957 REVB	
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	39199	<b>Drawing Revision</b> :	B	
	<b>Type</b> :	<b>Material</b> :		
	MACHINED PARTS	<b>Due Date</b> :	03/06/2008	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :				
<b>Comment</b> :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: B34975

*ST 08/05/31*

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

*ST 08/05/31*

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



**Comment:** INSPECT ALL DIM TO DIM SHEET

*ST 08/05/31*

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

*J.L 08/06/01*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*M-1/2/27*

*1X 08/06/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/05/2008 12:37:40 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39510

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(P)

START TIME:

1:05

OVEN TEMPERATURE:

320°

FINISH TIME:

1:35

FL 08/06/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(D)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-06-02

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(1x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

8/6/2

sy.

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03

Comment: FINAL INSPECTION/W/O RELEASE

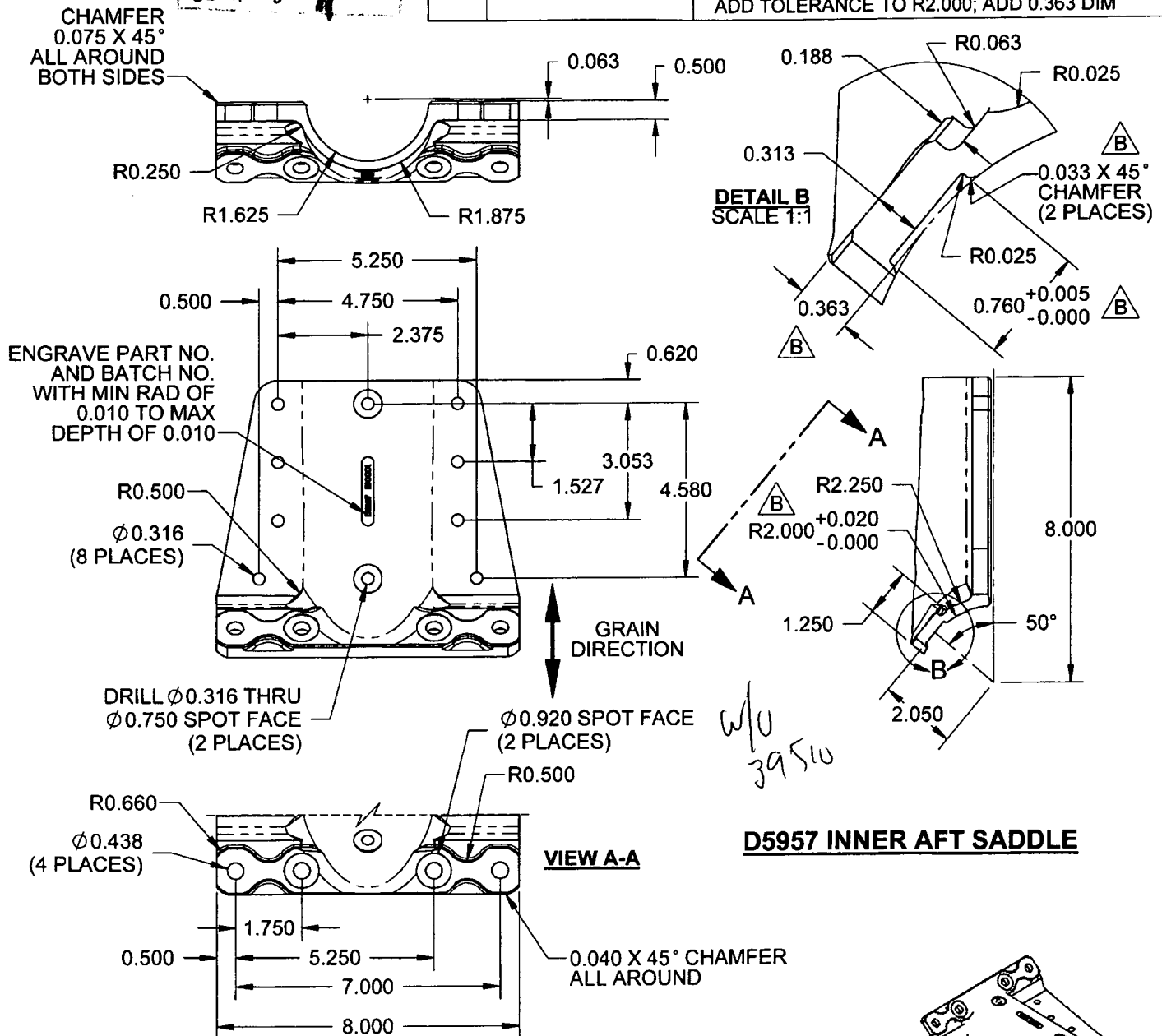
Job Completion



W 08/06/03

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>	REV. B SHEET 1 OF 1 SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39860
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		.319					
H	1.522	1.532		1.526					
I	3.048	3.058		3.052					
J	4.575	4.585		4.581					
K	0.313	0.318		.318					
L	0.495	0.505		.501					
M	0.490	0.510		.504					
N	1.865	1.885		1.875					
O	7.990	8.010		7.994					
P	2.240	2.260		2.250					
Q	0.307	0.312		.310					
R	0.760	0.765		.760					
S	0.490	0.510		.494					
T	1.625	1.645		1.632					
U	2.000	2.020		2.004					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: 28
Date: 08/05/31

Audited by: JL
Date: 08/06/01

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	